

Work Order ID 83254

April-16-12 1:33:18 PM

ASAP *Rash* *83254*

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 16/04/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/16* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3537	Rev C <input checked="" type="checkbox"/>

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

B

B12-4-18

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: *C* Prog Rev: *C* 2-Deburr
if necessary

110 0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B12-4-8

Quality Control

120 0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Sizel19

conts
x2

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-
Identify as D3537-1

50

5/16/12

140

140

Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
m121333 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any
weld that penetrated through Wearpad if necessary

50

12-04-23
182

150

150

QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

0.00

Memo

0.00

Sczklitz

ccub

50

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Item Name: Wearpad

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NS2

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Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

Sczkydz

cut
AZ

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:40

OVEN TEMPERATURE:

3200 F FINISH TIME:

3:10

50X *M-L*
12/4/24

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

M 117338

50X *JL Wlodar*

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Customer:

Reference:

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Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>FP-2</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

SUX

✓

12/4/24

12/4/25

12-04-25

W/O:		WORK ORDER CHANGES					
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2

Picklist Print

April-16-12 1:33:22 PM

Page 1

Work Order ID: 83254

83254

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 16/04/2012

Required Date: 23/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	234.1520	0.106	5.578947			

M304S16GA

304/316 Sheet .063

**

B.2-4-18

Location

Loc Qty

Loc Code

MAT020

234.152

120866

38.446

120877

137.326

121070

58.38

121070

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Dart Aerospace Ltd

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SHOP COPY

RETURN TO

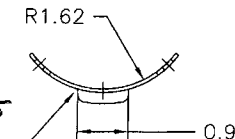
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT **SECTION A-A**

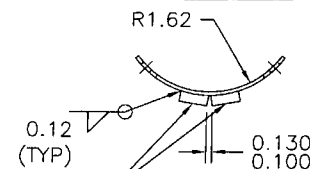
WITHOUT NOTICE

WORK ORDER

NO. **85254****MLC**
12/04/16

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

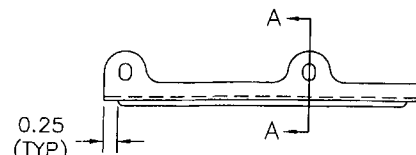
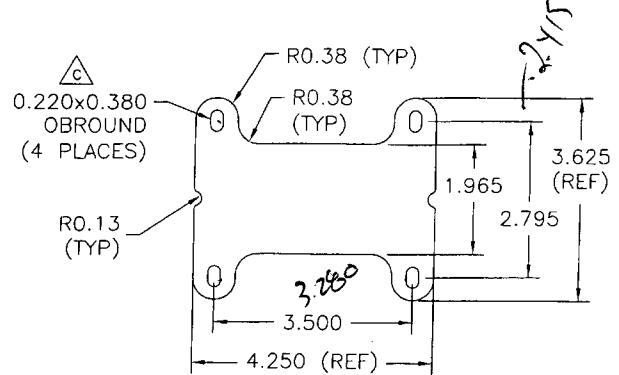
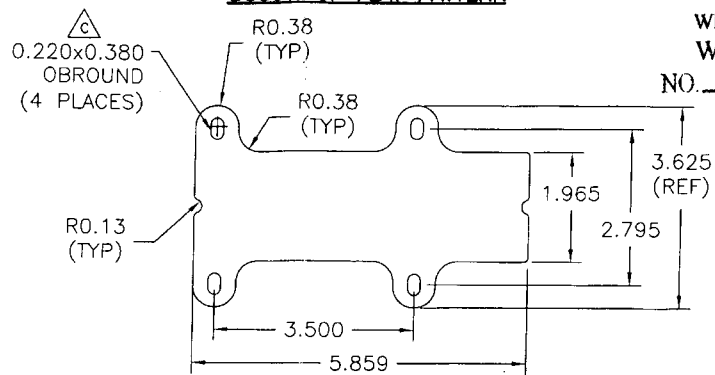
OK 11/11/15

SECTION B-B

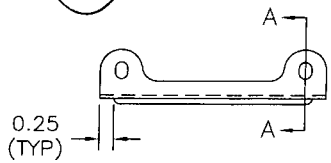
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
02.05.08 PH
PER ECN 962

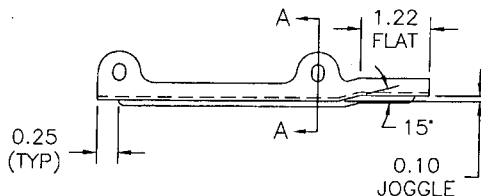
D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)

**D3537-1F FLAT PATTERN****D3537-3F FLAT PATTERN**

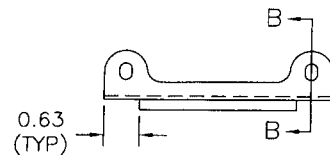
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)

**D3537-1/-3/-5/-7 WEARPAD NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

DART DART AEROSPACE USA, INC.

PORT WADSWORTH, OH

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